

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018276**Date Inspected:** 11-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay#9

During random visual inspection at bay#9 the QA inspector found that ZPMC personnel are installing bolt at service platform SP4, SP7 and SP8. This QA verified the bolt and found the bolts are not matching according to the approved shop drawing .The bolts should be galvanized bold. Than the QA informed the ZPMC QC Mr. Chen Shi Gang to check the drawing and install proper bolts. After that the ZPMC QC informs the fabrication supervisor and they removed the wrong bolt and installed new bolt according to the approved shop drawing. For more information see the attached photo.

During Quality Assurance (QA) random in process inspection on OBG Service Platform at Bay # 9 , this Caltrans QA Inspector observed the following issues that ZPMC has added four (4) weld joints after galvanization that are not detailed on the approved shop drawings. These joints were added without the Engineer's approval. These guardrail components are identified as SP7-13 and SP8-13. The type of pipes material used was Ø89mm extra strong pipe. The approved shop drawings are identified as SP7-8 and SP8-8. OBG Service Platform components are located at Bay # 9.

This QA inspector generated an incident report on this date.

Ultrasonic Testing (A,B,C and D-Scan)

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This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between side Plate to side Plate for OBG segment 11AE to 11BE at bike path side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found one rejectable indication at scanned area.

The Weld Designation is as follows

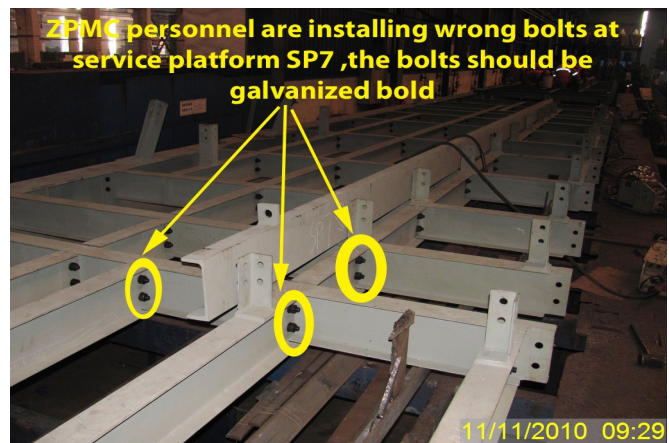
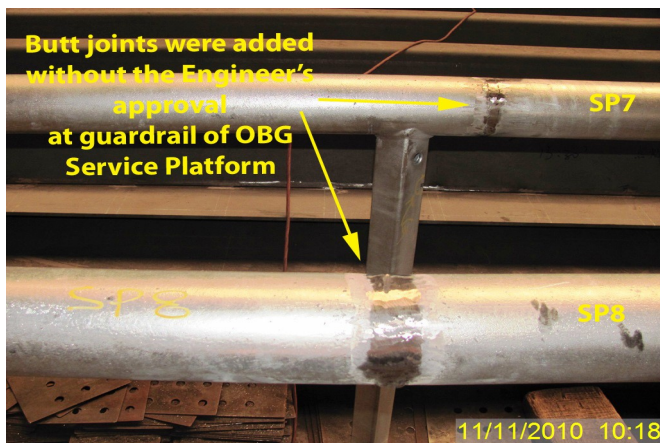
OBE11B-004

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between side Plate to side Plate for OBG segment 11AE to 11BE at bike path side . This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBE11B-005

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
